

Work Order ID 77934

77934

Page 1

Item ID: D2888

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 22/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/22 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2888	Rev A2
-------	--------

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks at 4.200" long
Grain along 4.200"*

OK/8 12-02-14 (x10)

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2888
Folio Rev: AA
Dwg Rev: A2

2-Deburr

OK/8 12-02-15 (x10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77934

77934

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December-22-11 2:45:23 PM

Item ID: D2888 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 22/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

of 12 02 15 (10)

B.A 12/02/16

10 6

A8 12-2-17 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77934

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December-22-11 2:45:23 PM

Item ID: D2888 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug
Start Date: 22/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 05/01/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:50								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 8:20								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 8485	0.00							
170									
Packaging	Memo	0.00							
Packaging									

10X PM / 12/02/22

10 BR 12-2-22

(10X) SP 12-02-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 77934***77934***

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Item ID: D2888 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug
Start Date: 22/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 05/01/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

[Signature] M.L.J. 12/02/22

12-02-22
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-22-11 2:45:27 PM

Page 1
1

Work Order ID: 77934

77934

Parent Item: D2888

D2888

Parent Item Name: Lug

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	9.6000	0.39	2.34			

M6061T6B2 500X03 500

6061-T6 Bar 2.50 x 3.50

**

25 12 02 14

Location

Loc Qty

Loc Code

MAT008

9.6

113403

1.6

118071

8

~~2.34~~ 3.9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

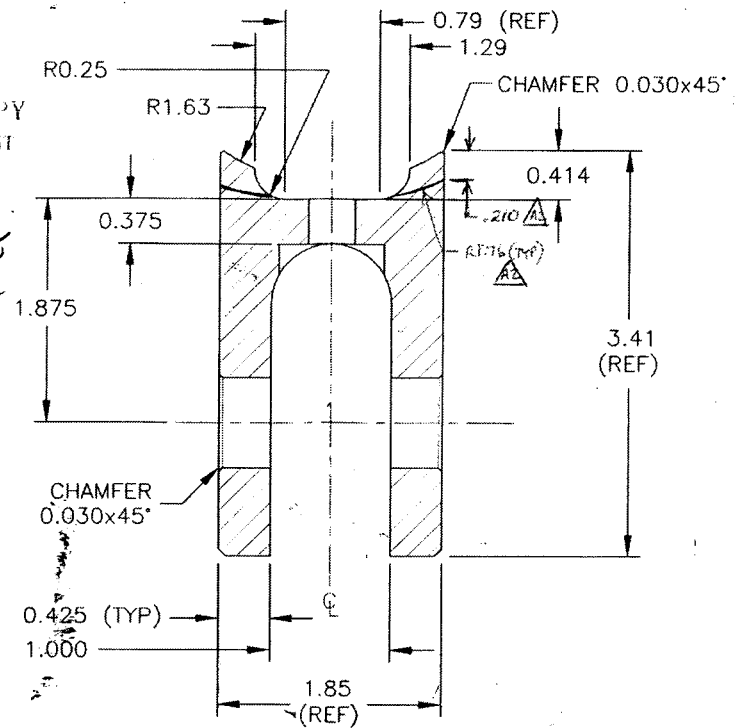
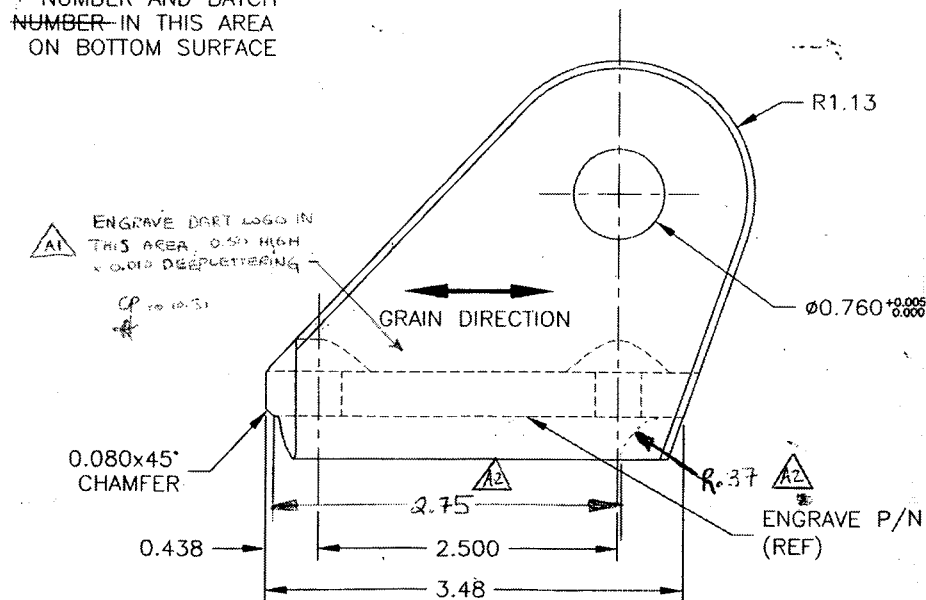
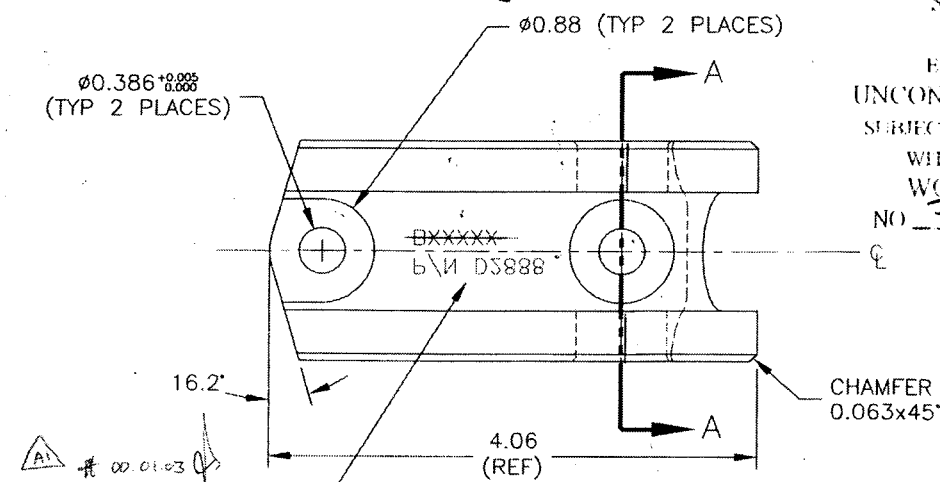
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 77934
M.L.S.
11/12/22



SECTION A-A
SCALE 1:1

RELEASED
99.07.01 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Sulfate Clearance for NCR 754
A1	05.10.21	Update Engraving

A	99.06.21	NEW ISSUE
DESIGN	CP	DART DART AEROSPACE LTD HAWESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2888
DATE	99.06.21	TITLE LUG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	77734
Description: <u>Lug</u>		Part Number:	02888
Inspection Dwg: 02888	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.386	+0.005/-0.000	.388	✓		caliper	RT-4
.88	+/- .030	.876	✓		"	"
.063	+/- .010	.065	✓		"	"
4.06	+/- .030	4.047	✓		height gauge	3/006
1.29	+/- .030					
1.29	+/- .030	1.286	✓		caliper	RT-4
.030	+/- .010	.028	✓		"	
.210	+/- .010	.200	✓		"	
.414	+/- .010	.404	✓		"	
3.41	+/- .030	3.409	✓		"	
1.85	+/- .030	1.856	✓		"	
1.000	+/- .010	1.003	✓		"	
.425	+/- .010	.424	✓		"	
1.875	+/- .010	1.87	✓		height gauge	3/006
.375	+/- .010	.373	✓		caliper	RT-4
.760	+0.005/-0.000	.760	✓		"	
2.75	+/- .030	2.85	✓		"	
2.500	+/- .010	2.5	✓		"	
3.48	+/- .030	3.488	✓		"	
0.010	+/- .010	.009	✓		"	

Measured by: <u>JS / mkr</u>	Audited by: <u>B.A</u>	Preliminary Approval: <u> </u>
Date: <u>12-02-14</u>	Date: <u>12/02/16</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15